



Product information

4CR-Industry 45-110 EP 2K Primer HB

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Product description

Epoxy 2K primer with active protection against corrosion, can be used as priming coat even for both underwater and chemical protective coatings and as intermediate coating for 42-150 2K Zinc-rich Primer Coating grey. Excellent adhesion to steel, zined substrates, aluminium, GRP and mineral substrates.

Hardener

0451-355 EP Hardener fast, 0451-360 EP Hardener medium

Mixing ratio

Paint + hardener 3:1 by volume

Paint + hardener 5:1 by weight

Pot life

7 - 9 hours at 20 °C

Dilution

0530-440 EP Thinner, addition 5 - 25 %

Spraying viscosity 4 mm DIN

Gravity spray gun 20 - 30 s

Airless / Airmix 30 - 40 s

Application method

Application method	Thinner	Pressure	Nozzle
Roll and brush	5 - 10 %	-	-
Gravity spray gun	20 - 25 %	2 - 2,5 bar	1,5 - 1,8 mm
Airless / Airmix	10 - 15 %	100 - 120 bar	0,28 - 0,33 mm

Processing conditions

Ensure an adequate supply and exhaust air ventilation. Working temperature must be at least +10 °C. Max. air humidity 80 %.

Spraying operations

Gravity spray gun 2 - 3

Airless / Airmix 1 - 2

DFT

50 - 70 µm

Consumption

6,9 - 9,6 m²/l

5,3 - 7,4 m²/kg

Drying

Object temperature 20 °C

Dust free after 40 - 55 minutes

Set to touch after 4 - 5 hours

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ready for assembly after 10 - 12 hours

recoatable after 1 hour

Object temperature 60 °C

ready for assembly after 45 minutes

recoatable after 1 hour

Recoatable at the earliest after 1 hour and at the latest after 24 hours. After drying > 24 h, requires intermediate sanding.

Technical specifications

Binder base: epoxy resin

Density DIN EN ISO 2811 (kg/l): 1,4 - 1,5

Solids content (% by volume): 44 - 45

Solids content (% by weight): 65 - 68

Delivery viscosity DIN 53211 4 mm (in s): Thixotropic

Gloss level ISO 2813 at 60° (GU): < 20 mat

Short-term heat resistance: 180 °C

Permanent heat resistance: 150 °C

VOC regulation

EU limit value: Category B/c 540 g/l. This product ready to use contains max. 540 g/l.

Features

Active protection against corrosion (zinc phosphate), electrostatic application possible, excellent resistance to chemical and mechanical strains, suitable to insulate thermoplastic substrates, adhesion on steel, zinc coated substrates, aluminium and GRP.

Storage

At least 3 years in unopened original container

Substrate preparation

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!

Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.

steel:

blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly

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de-rust with hand and power tools to degree of cleanliness St 3
degrease with Anti-Silicone

zincated substrates:

clean the surface with ammonia solution
sweep blast

aluminium:

degrease with 4CR AC Thinner, sand thoroughly with sandpaper P 360/400 and clean subsequently with Anti-Silicone

GRP:

clean (remove completely any mould release agents), sand slightly if necessary and degrease again with Anti-Silicone

Proposed coating structure

steel, zincated substrates, GRP:

priming coat: 45-110 EP 2K Primer HB with 50 - 70 µm dry film thickness

finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

aluminium:

priming coat: 45-110 EP 2K Primer HB with 25- 30 µm dry film thickness

finishing coat: *72-166 AC 2K Topcoat RB glossy with 50 - 60 µm dry film thickness

*Further 4CR finishing coats are available. Please contact your technical adviser or our application technicians.

Processing tips

For professional use only.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

Cleaning of tools

Clean tools immediately after use with 0530-440 EP Thinner.